

Work Order ID 70114

Friday, May 27, 2011 8:23:02 AM



Page 1

Item ID: D2891-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.25 Support

Start Date: 5/27/2011 Start Qty: 2.00




Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 2.00



Customer:

Reference: rework

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2891

Rev A1

125

0.00



Crosstubes

Memo

0.00

Crosstubes

PULL FROM W/O 68088:

1 X D2891-1 B50952

1 X D2891-1 B53773

-BUFF OFF MAGNABOND

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

RE-POWDERCOAT PER DRWG D2891

START TIME:

400°F

OVEN TEMPERATURE:

FINISH TIME:

9:15

9:45

RT 11-05-28 (2)

2x of m.f 11/05/28

M116964

Work Order ID 70114

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Page 2

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

25 11 05 30 (2)

150

Identify as per dwg & Stock Location: *x tube*

0.00



Packaging

Memo

0.00

Packaging

RESTOCK USING NEW B/N

25 11 - 05 - 30 (2)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30 *[Signature]*
11/05-30
[Signature]

Picklist Print

Friday, May 27, 2011 8:22:59 AM

Page 1

Work Order ID: 70114

Parent Item: D2891-1

Parent Item Name: 2.25 Support



Start Date: 5/27/2011

Required Date: 5/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 02.11.26 Added P/O: KJH
IPP D 08.03.19 Re-format EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2891-1		Manufactured	No				Each	13.0000		2			
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2.25 Support



BT 11-05-27

Location

Loc Qty

Loc Code

LG052

13

53773

11

62595

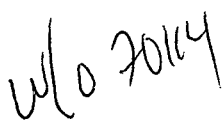
2


50952

1

1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



A1	# P 02.01.23	UPDATE PWD AS MANUFACTURED	
A	00.11.17	NEW ISSUE	
DESIGN	DRAWN BY	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	REV.
CHECKED	APPROVED		SHEET 1 OF
DATE		TITLE	SCALE
00.11.17		Ø2.250 SUPPORT	1

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HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV.
D2891	SHEET 1 OF

REV. 1/78

SHEET 1 OF 1

SCAL